

Ship Oct. 3

Spent into  
SB 07/10/03Date: Monday, 10/1/2007 1:37:22 PM  
User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ARM  
 Job Number : 34919  
 Estimate Number : 12172  
 P.O. Number :  
 This Issue : 10/1/2007 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 11 Type : SMALL / MED FAB  
 Previous Run :  
 Written By :  
 Checked & Approved By : JA 07.10.01  
 Comment : Est. B 02.03.18 Added pick list NG

Part Number : D2066  
 Drawing Number : D2066 REV B  
 Project Number : N/A  
 Drawing Revision : B  
 Material :  
 Due Date : 10/8/2007 Qty: 3 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M304TR0500W035 304 RD Tube .500 x .035W



Comment: Qty.: 2.5043 f(s)/Unit Total : 7.5128 f(s)  
 304 RD Tube .500 x .035W  
 Punch 1/2" OD x .035" Wall 304/316 SS Seamless Tube  
 (Ref QSI 017 4.1.1.2) as per Dwg D2066  
 Use punch Jig DT8012  
 Batch: 4105575

SB

2.0 D2052 Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)  
 Bracket  
 Pick:  
 Qty Part number Description Batch  
 2 D2052 Bracket B17214

SB

3.0 D2055 Clamp



Comment: Qty.: ~~2.0000~~ 1.0000 Each(s)/Unit Total : 6.0000 Each(s)  
 Clamp 1.0  
 Pick:  
 Qty Part number Description Batch  
 1 1A D2055 Clamp B28323

SB

4.0 D2056 Bell Crank Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)  
 Bell Crank Assembly  
 Pick:  
 Qty Part number Description Batch  
 1 D2056 Bellcrank B17049

SB 07/10/03





## Process Sheet

ier: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

umber: 34919

Part Number: D2066

nber:



sq. #:

Machine Or Operation:

Description:

5.0

D2054

Bushing - Delrin



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)

Bushing - Delrin

Pick:

Qty

Part number

Description

Batch

2

D2054

Bushing

B16711

SB 07/10/03 9

6.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Slide on parts per Dwg and W/O for D2676-043

PTO

Punch other end to length (28.62") as per Dwg D2066

Bend per Dwg D2066

Drill 3/16" Dia holes per Dwg D2066

Deburr

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SA 07/10/03

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

N/A - R

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Record D2066 Batch number on W/O for D2676-043



# Process Sheet

Number: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Number: 34919

Part Number: D2066

Number:



eq. #:

Machine Or Operation:

Description :

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

7/10/3 SC (1)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



07.10.03

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 87.10.03

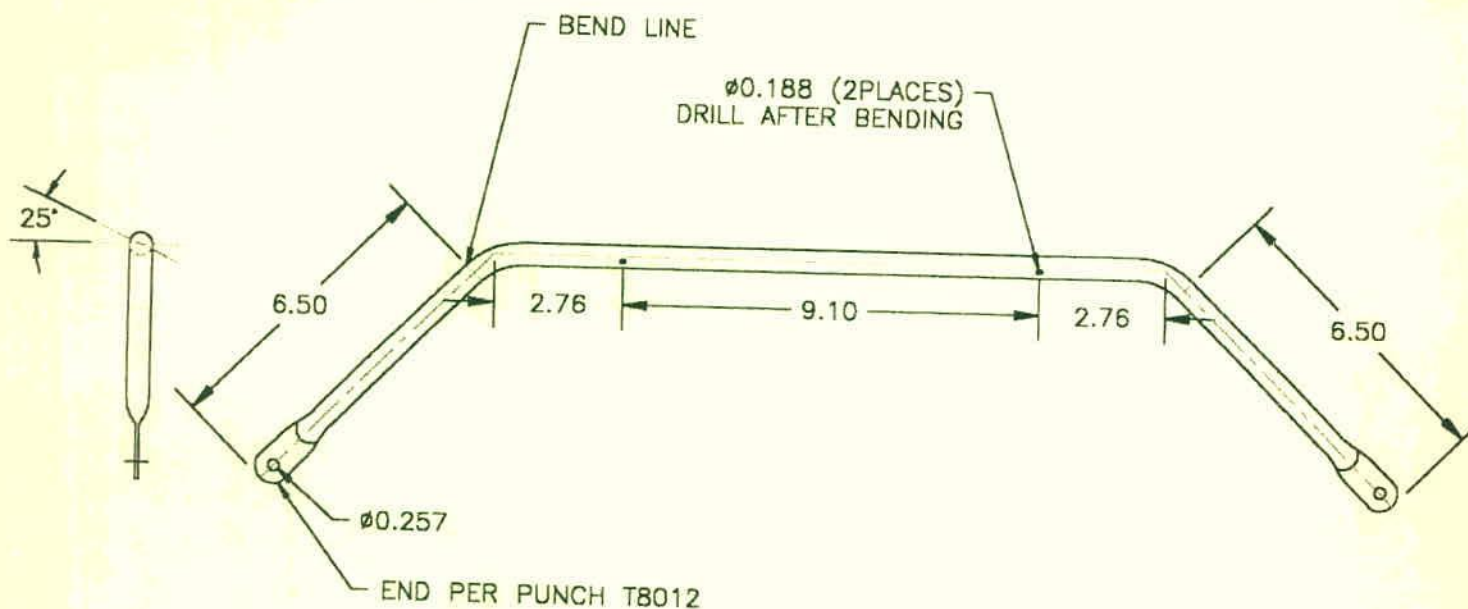




**DART**



DESIGN	DRAWN BY	TITLE	REV.
B WILLIAMS	B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF
DATE		ARM	SCA
92.03.12		RE-DESIGNED	
B	96.02.06		



D2066 CUT LENGTH 28.62  
NOTE:  
ADD D2052,D2055,D2056  
D2054 TO ARM BEFORE  
ENDS ARE PUNCHED AND  
ARM IS BENT

MATERIAL: 304/316 SS 1/2 OD X 0.035 WALL

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 34919





W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/10/03	6	split WO	SB	07/10/03	1		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

